

Work Order ID 86336

June-27-12 3:17:34 PM

\*86336\*

Page 1

Item ID: D350-578-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Bearpaw

Stop

\*NS2\*

Start Date: 27/06/2012 Start Qty: 800

\*8\*

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 800

\*8\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2432	Rev F3
-------	--------

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

0.00

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

160

\*160\*

Packaging

Packaging

Pick Kit

0.00

Memo

0.00

5 12/07/06 JB

170

\*170\*

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

S.2012

(TS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 86336**

June-27-12 3:17:34 PM

**\*86336\***

Page 2

Item ID: D350-578-011

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Bearpaw

Stop

**\*NS2\***

Start Date: 27/06/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
<b>*180*</b> Packaging	Packaging	0.00							
Packaging	Memo	Identify and pack for shipping as per PPP D350-578-011 Location:							
		<i>F6012 Next</i>							<i>6/27/12 (5)</i>
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b> QC	Memo	0.00							
Quality Control									<i>MJS 12/07/10</i>
									<i>MF 12-07-10</i>

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

June-27-12 3:17:39 PM

Page 1

Work Order ID: 86336

Parent Item: D350-578-011

Parent Item Name: Bearpaw

\*86336\*  
\*D350-578-011\*

Start Date: 27/06/2012

Start Qty: 8.00

Required Date: 11/07/2012

Required Qty: 8.00

**Comments:**  
 IPP Rev:A New Issue 07-01-02 JLM  
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC  
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A		Purchased		No		160	Each	562.0000	12	96.70	✓		

*Safety Bolt*  
\*AN4-17A\*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST358	300	
116704	0	
121541	300	
ST359	262	
112314	0	
121011	200	
121068	62	

D2182B                      Manufactured No

160 f 122.8682 2.5 20 ✓

\*D2182B\*

Rubber Cushion

*repaired*  
Cut qty 6 at 5.00" long

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST410	122.86817	
63413	1.6	
66063	41.61817	
73932	79.65	

\*\*

*JB 12/07/06*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 86336

Parent Item: D350-578-011

Parent Item Name: Bearpaw

\*86336\*  
\*D350-578-011\*

Start Date: 27/06/2012

Start Qty: 8.00

12 96

Required Date: 11/07/2012

Required Qty: 8.00

D2274

\*D2274\*

Radius Block

Manufactured No 160 Each 759.0000

\*\*

JB

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST007	759	
78233	2	
81958	96	
83258	210	
84199	251	84199
85455	200	

D2432

\*D2432\*

206 (24") Bearpaw

Manufactured No 160 Each 1.0000

\*\*

84063 906  
81044 1488

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST499	1	
81044	1	

D2438

\*D2438\*

Clamp

Manufactured No 160 Each 142.0000

\*\*

806 120706

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST456	142	
77038	6	
83265	28	
83266	50	
84804	58	84804

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 86336

Parent Item: D350-578-011

Parent Item Name: Bearpaw

\*86336\*  
\*D350-578-011\*

Start Date: 27/06/2012

Start Qty: 8.00

Required Date: 11/07/2012

Required Qty: 8.00

D2529

Manufactured

No

160

Each

761.0000

12 96

\*\*

\*D2529\*

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST010	761	
79485	18	
81873	243	81873
84435	500	

MS2104214

Purchased

No

160

Each

1,920.000

12 96

\*\*

\*MS2104214\*

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1920	
119075	116	
121011	193	
121444	1311	121444
121652	300	

NAS1149D0463J

Purchased

No

160

Each

2,782.000

24 192

\*\*

\*NAS1149D0463J\*

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	90	
104746	3	
116805	0	
119097	27	
121255	49	
121708	11	
ST299	2689	
121912	2689	121912
ST351	3	
107321	3	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

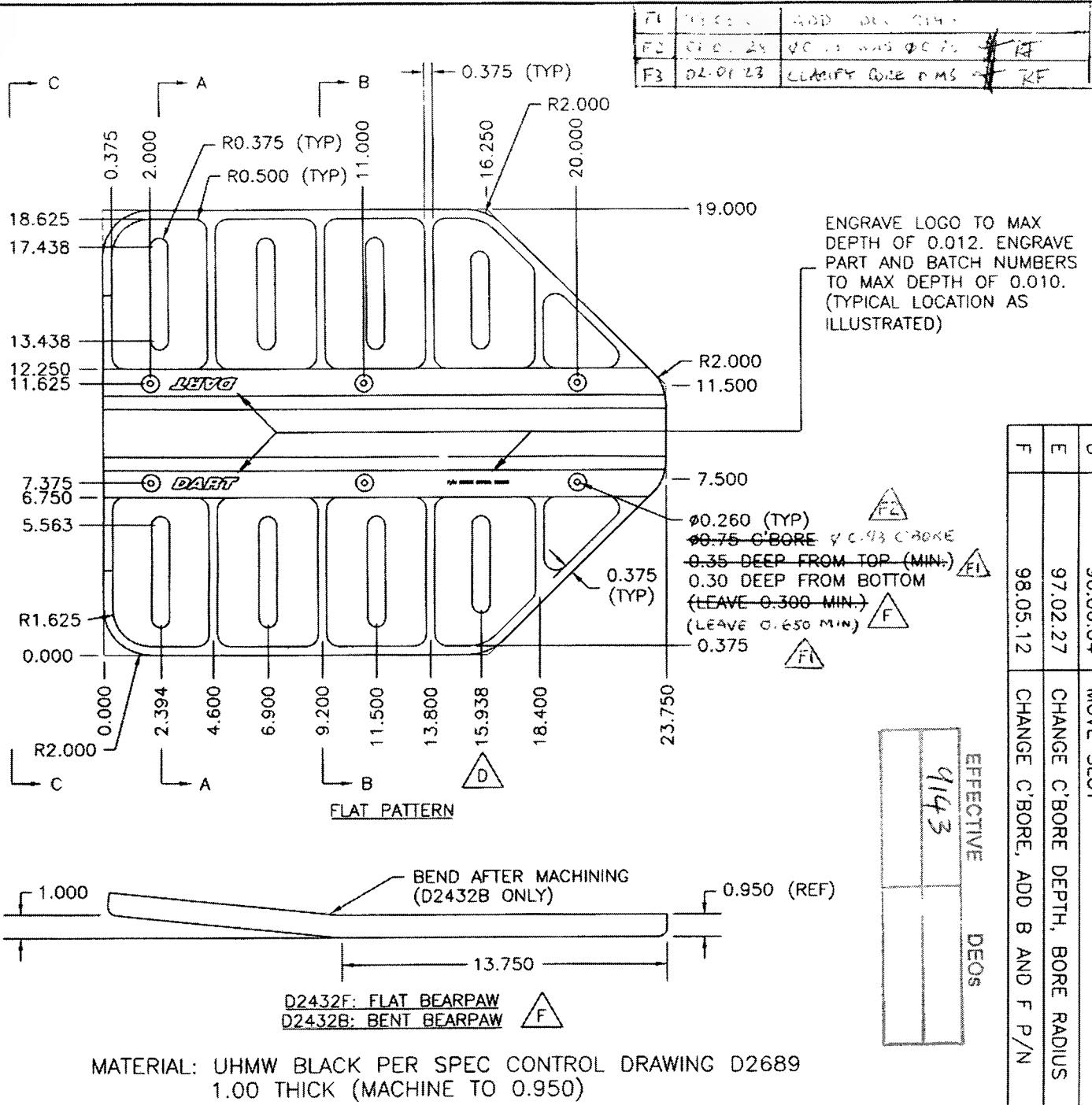
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 860336 MLJ  
 12/06/28



DESIGN KE	DRAWN BY KG	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2432
DATE 98.05.12	TITLE BEARPAW	REV. F SHEET 1 OF 2 SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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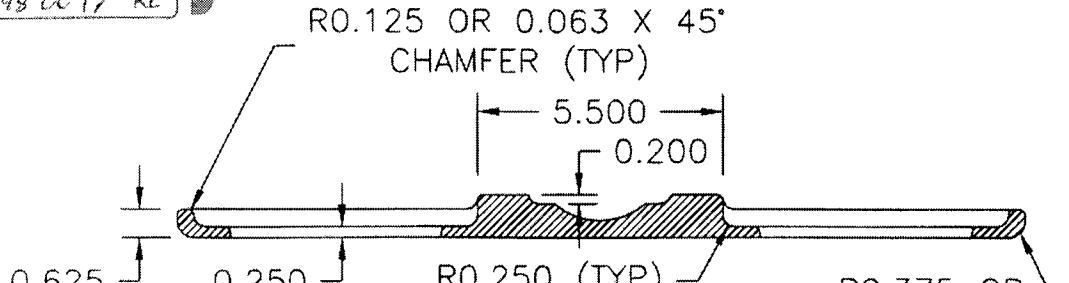
NOTE: Date & initial all entries

*26236*  
**DART**

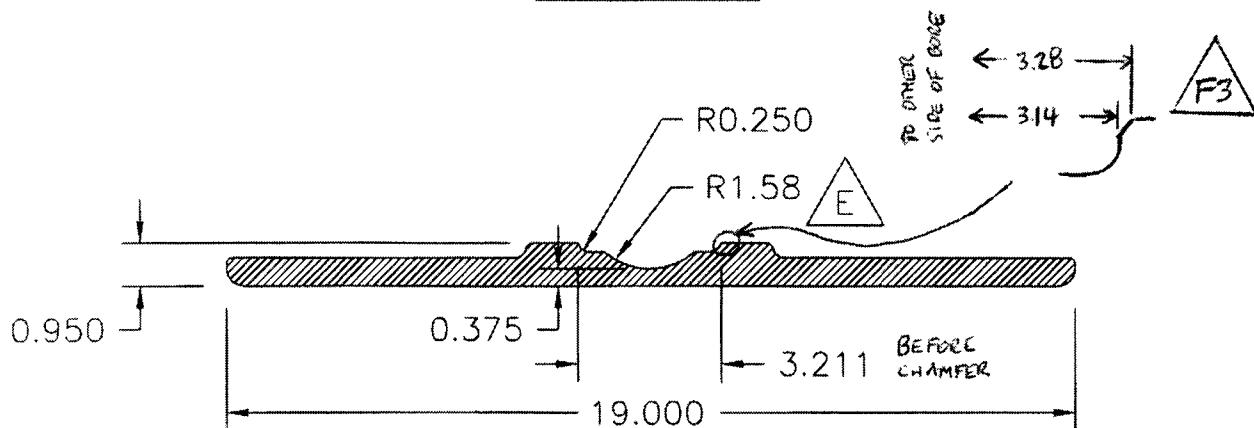


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>BM</i>	APPROVED <i>JS</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

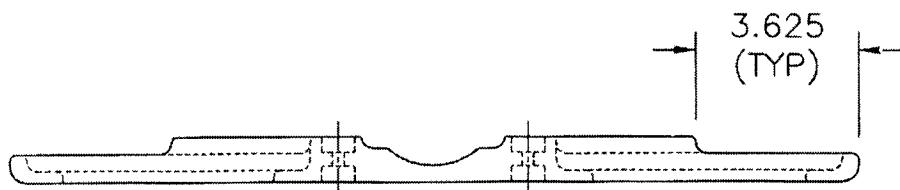
**RELEASED**  
98 OC 17 KE



SECTION A-A



SECTION B-B



SECTION C-C

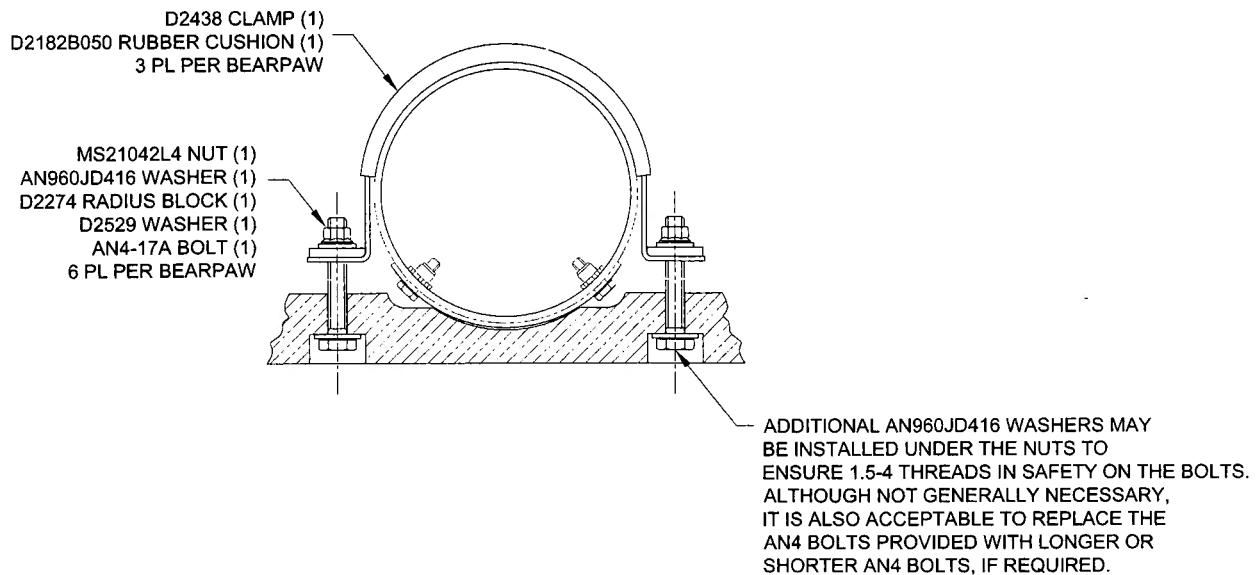
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**Section A-A**  
*Figure 4 – Clamping Detail*

## 5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	<b>BEARPAW INSTALLATION</b>
	X	D350-578-021	<b>BEARPAW INSTALLATION</b>
/ 6	6	D2182B050	Rubber Cushion
/ 12	12	D2274	Radius Block
/ 12	12	D2529	Washer
/ 6	6	D2438	Clamp
/ 2	2	D2432F	Bearpaw
	2	D2672F	Bearpaw
/ 12	12	AN4-17A	Bolt
/ 24	24	AN960JD416	Washer
/ 12	12	MS21042L4	Nut (or MS21042-4)

Work Order ID 86336

\*86336\*

June-27-12 3:17:34 PM

Page 1

Item ID: D350-578-011

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bearpaw

Start Date: 27/06/2012 Start Qty: 800

\*8\*

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 800

\*8\*

Customer:

Reference:

Approvals: Process Plan: *OK*

Date: *6/27/12* Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D2432	Rev F3
100	0.00

**\*100\*** DOCUMENT CONTROL  
DC  
Document Control

Memo  
Photocopy bluefile and create labels per PPP D350-578-011 CHG005

*6/27/12*

160	Pick Kit	0.00
-----	----------	------

**\*160\***  
Packaging  
Packaging

Memo

170	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

**\*170\***  
QC  
Quality Control

Memo

W/O:		WORK ORDER CHANGES					
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